

**ABSTRACT OF THE DISCLOSURE**

A machine tool in which the workpiece is transported by a pair of longitudinal carriages with transverse and vertical carriages supporting the workpiece holders to a machining region from a workpiece replacement region. In the machining region the workpiece is displaced relative to the tool and possibly rotated. In the workpiece replacement region, the workpiece is replaced in the machine tool by a workpiece which has not been machined.

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